

Work Order ID 115477

April-02-14 10:22:23 AM

115477

Page 1

Item ID: D5078-1

Revision ID:

Item Name: Bracket

Start Date: 4/02/14

Start Qty: 20.00

20

Required Date: 4/10/14

Req'd Qty: 20.00

20

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5078

REV A

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D5078

Dwg Rev: _____

Prog Rev: _____

2-Deburr as required

0.00

0.00

28

mm/2 14/04/04

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

28

mm/2 14/04/04

shp April 11

D5078-1
B115477

2.281

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Item ID: D5078-1

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Start Date: 4/02/14

Start Qty: 20.00

20

Required Date: 4/10/14

Req'd Qty: 20.00

20

Reference:

Approvals:

Process Plan: _____ Date: _____

QC: _____ Date: _____

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

0.00

4/4/14

27

120

QC

Memo

Quality Control

132

Bend as per dwg

0.00

DAS

30

9-89

0.00

27

14/04/09

132

Brake NC

Memo

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

0.00

4/4/10

27

150

QC

Memo

Quality Control

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Ship Monday @ 14/04
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Item ID: D5078-1
Revision ID:
Item Name: Bracket
Start Date: 4/02/14 Start Qty: 20.00 *20*
Required Date: 4/10/14 Req'd Qty: 20.00 *20*
Reference:

Accept *N900040100* Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160	HandFinish	0.00				27	26	14/4/11	
Hand Finishing	Memo								
161	QC7-Inspect Chemical Conversion Coat	0.00							
161	QC	0.00				27	28	14/04/14	DAS 34 9:59
Quality Control	Memo								
162	White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum	0.00							
162	Powdercoat	0.00				27	0	14-4-14	DAS 34 9:59
Powder Coating	Memo								

START: 9:30
QW. T: 3:30
FINISH: 1:00

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Item ID: D5078-1

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Item Name: Bracket

Start Date: 4/02/14

Start Qty: 20.00

20

Required Date: 4/10/14

Req'd Qty: 20.00

20

Reference:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

163

QC3- Inspect Part Finish

0.00

163

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: ST139B

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

27
can

27x DAS 28 9-89 APR 14 2014

14-04-14

14-04-14

Picklist Print

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Parent Item: D5078-1

D5078-1

Parent Item Name: Bracket

Start Date: 4/02/14

Required Date: 4/10/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 14-04-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

sf

244.7500

2

M6061T6S 050

EL

14-4-4

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT

96

M128408

96

MAT021

148.75

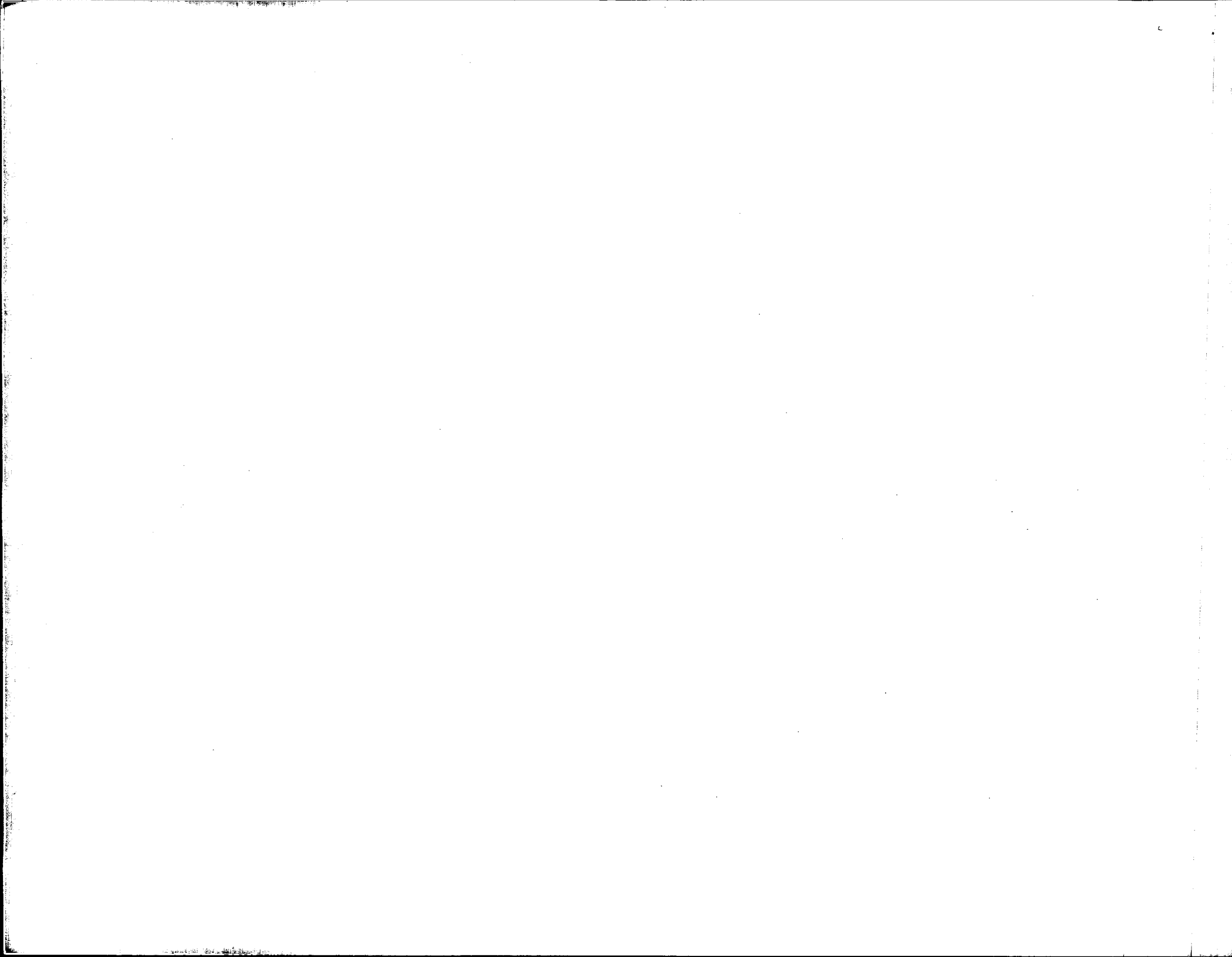
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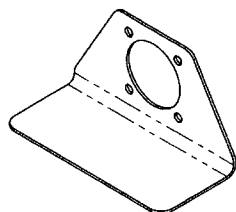
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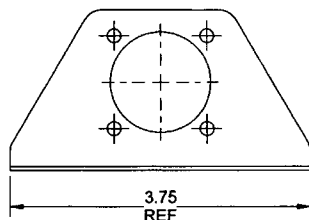
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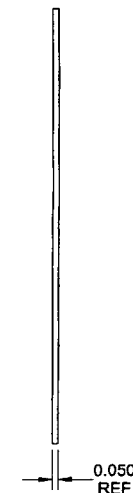
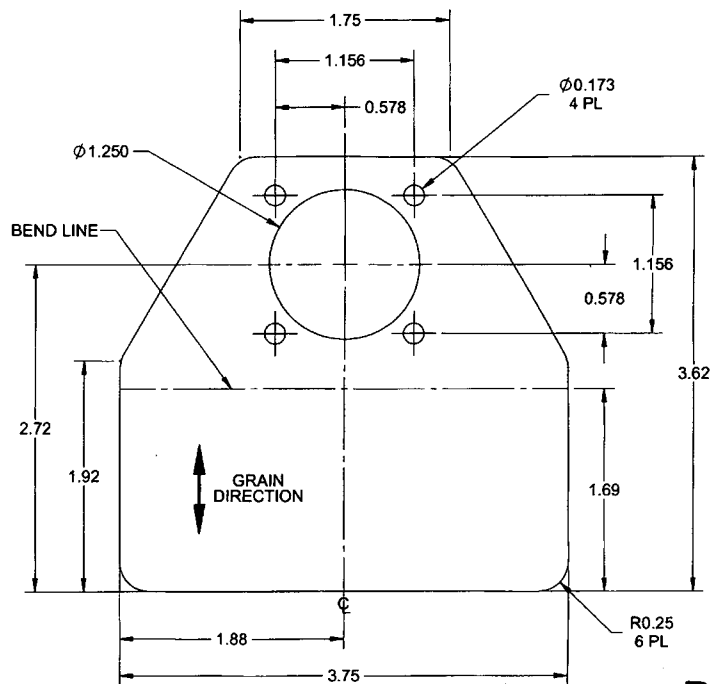
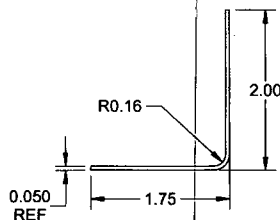




w/b 115477



D5078-1 BRACKET
MAKE FROM D5078-1F FLAT PATTERN



D5078-1F FLAT PATTERN BRACKET

RELEASED
2014-03-31

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.050 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

APPROVED

A		NEW ISSUE		RF	14.03.17	
REV.		DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	RF					
CHECKED	DC	DRAWING NO.	REV. A			
MFG. APPR.	JLM	D5078	SHEET 1 OF 1			
APPROVED	HS	TITLE	SCALE			
DE APPR.	DS	BRACKET	NT			
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